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IS 8857 (1989): Canvas Water Bucket [TXD 20: Made-up Textiles]



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Indian Standard

CANVAS WATER BUCKET—SPECIFICATION

(*First Revision*)

भारतीय मानक

कैनवास को पानी की बाल्टी — विशिष्ट

(पहला पुनरीक्षण)

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FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards on 23 December 1989, after the draft finalized by the Made-Up Textiles (Other than Ready-Made Garments) Sectional Committee had been approved by the Textile Division Council.

Revision of this Standard has been taken up on account of supersession of IND/TC/2451 (b) by JSS 7240-1 by Ministry of Defence, on which the standard was based.

In the present revision the following major changes have taken place:

- a) For waterproof cotton canvas, conformance has been indicated as per existing Indian Standard.
- b) The requirement for 'freedom from defects' has been included.
- c) The requirement for 'waterproofness test' has been modified.
- d) Sampling clause has been modified and 'criteria for conformity' has been introduced.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

CANVAS WATER BUCKET—SPECIFICATION

(First Revision)

1 SCOPE

1.1 This standard prescribes the requirements of canvas water bucket (without lid) made from waterproof cotton canvas.

2 REFERENCES

2.1 The following Indian Standards are necessary adjuncts to this standard:

IS No.	Title
280 : 1978	Specification for mild steel wire for general engineering purposes (<i>third revision</i>)
1424 : 1983	Specification for cotton canvas (<i>third revision</i>)
1720 : 1978	Specification for cotton sewing threads (<i>second revision</i>)
2818 (Part 2) : 1971	Specification for Indian hessian : Part 2 305 and 299 g/m ² at 16 percent contract regain (<i>first revision</i>)
3751 : 1966	Specification for heavy cee cloth
6359 : 1971	Method for conditioning of textiles
6803 : 1972	Specification for special proofed canvas and duck

3 MATERIALS

3.1 The requirements of waterproof canvas, cotton sewing thread and galvanized mild steel wire to be used in the manufacture of canvas water bucket shall be as given below:

Sl No.	Material	Requirement
(1)	(2)	(3)
i)	Proofed canvas (<i>see</i> Notes 1 and 2)	Conforming to IS 6803 : 1972
ii)	Cotton sewing thread 270 d tex \times 9 (22s/9)	Of matching shade and conforming to variety No. 35 of IS 1720 : 1978
iii)	Mild steel wire, galvanized 6.3 mm dia	Conforming to IS 280 : 1978

NOTES

1 Base fabric conforming to variety No. 2 of IS 1424 : 1983 shall be used for the manufacture of waterproof canvas.

2 In case of supplies meant for Defence, waterproof cotton canvas shall have olive green shade.

4 MANUFACTURE

4.1 The design and dimensions of the bucket shall be as shown in Fig. 1.

4.2 Body

The fabric shall be stitched in such a way that the warp shall be along the height of the bucket. The vertical seam of the body shall be hook jointed and sewn with two rows of stitching (*see* side seam in Fig. 1).

4.3 Bottom

A strengthening strip made from double folded canvas, stitched at the middle shall be secured to the bottom by two rows of stitching prior to attachment to the body. The round edge of the bottom shall be secured to the body with a half-hooked joint in a circular form with two rows of stitching (*see* bottom joint in Fig. 1).

4.4 Handles

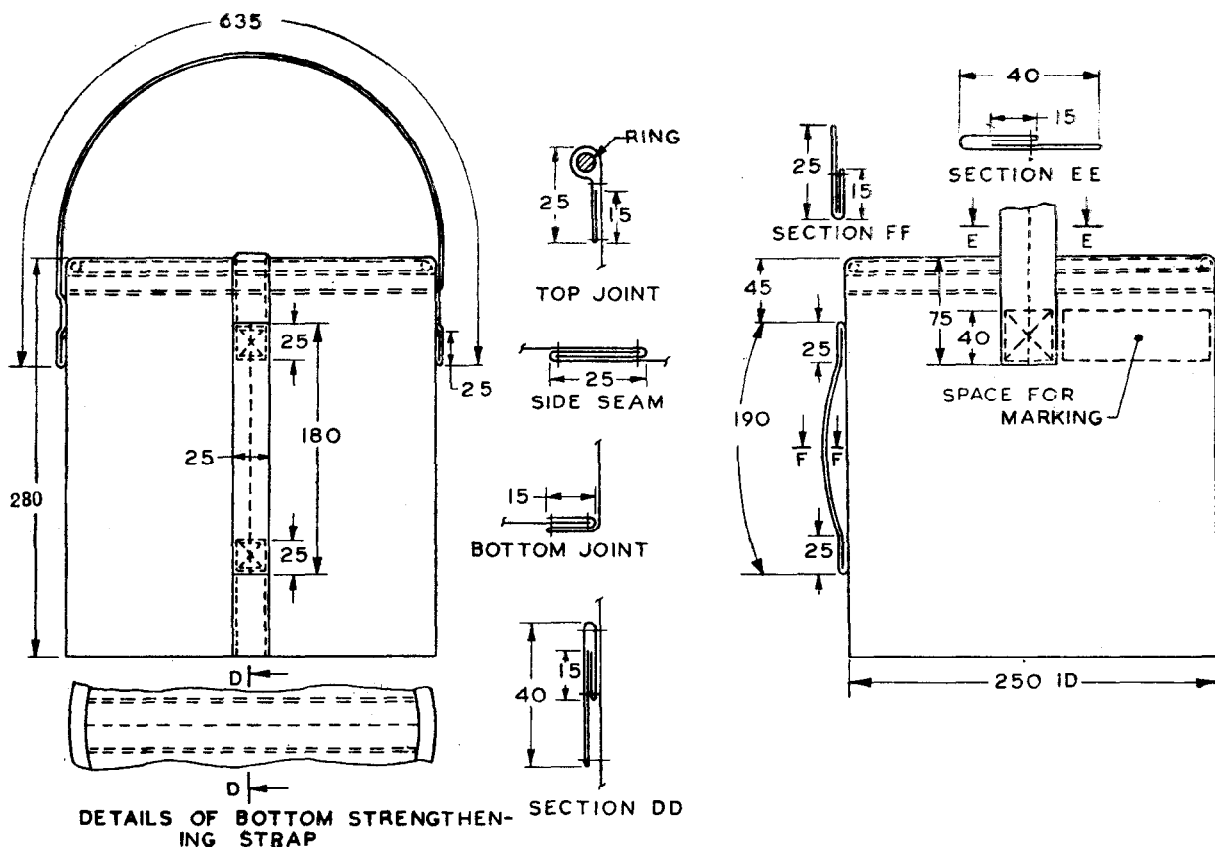
The handles shall be made from double folded canvas and stitched at the middle. The top handle, serving as carrying handle, shall be secured to the body at the open-mouth of the bucket by stitching the ends of the handle strip to the bucket in the the manner and position as shown in Fig. 1.

4.5 Ring

A circular ring made from mild steel, galvanized wire (*see* 3.1) the ends of which have been butt welded and finished smooth, shall be secured with two rows of stitches at the mouth of the bucket to form a rim.

4.6 Stitching

The bucket shall be machine stitched throughout with cotton sewing thread (*see* 3.1). The number of stitches per decimetre shall be between 20 to 30 and all the loose ends shall be securely fastened off.



All dimensions in millimetres.

FIG. 1 BUCKET WATER CANVAS

4.7 Freedom from Defects

The buckets should be free from sewing and other fabrication and basic fabric defects.

5 REQUIREMENTS

5.1 General Make-up

The general make-up of the bucket shall be as shown in Fig. 1.

5.2 Dimension

5.2.1 The finished dimensions of the bucket shall be as under:

Length (mm)	280 ± 15
Diameter (mm)	250 ± 5

5.3 Waterproofness Test

5.3.1 The bucket shall be filled with water to its brim and kept suspended in an up-right position, in conditioned atmosphere, that is, 65 ± 2 percent relative humidity and $27 \pm 2^\circ\text{C}$ temperature (see IS 6359 : 1971). After six hours the bucket shall be examined

for any sign of leakage. The bucket shall not show any sign of leakage. However, the moistening of outer surface shall be permitted.

5.4 Appearance, Workmanship and Shade

5.4.1 If in order to illustrate or specify the characteristics, such as workmanship, general appearance, feel and shade of the bucket which are not included in the specification a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

5.4.2 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

6 MARKING

6.1 Each bucket shall be legibly marked in letters, at least 10 mm in height, with indelible ink, between handle joints on the upper side, with the following:

- Indication of the source of manufacture;
- Year of manufacture;

- c) Height (mm) and diameter (mm); and
 d) Any other information required by the buyer.

7 PACKING

7.1 The canvas buckets shall be packed as specified in the contract or order. Otherwise, the packing may be done as follows:

Each bucket shall be pressed flat, five such buckets shall be tied with 3-ply jute twine to form a bundle. Two rows, each containing three sets of two bundles, placed side by side shall be wrapped with a single layer of heavy cee jute cloth (*see* IS 3751 : 1966) or with two layers of hessian 305 g/m² [*see* IS 2818 (Part 2) : 1971] to form bale of rectangular shape.

The overlapping of inner layer (hessian) shall be at least 15 cm so as to ensure full protection to the contents of the bale. The overlapping of the outer layer shall be such that it can be properly and securely sewn at the sides of the bale.

The bale shall be stitched with double, 3-ply jute twine with not less than 12 stitches per dm taking care that the contents of the bale are not pierced during stitching. Sufficient cloth (heavy cee or hessian) shall be pulled out at each corner of the bale to form ears of about 15 cm in length. The gross mass of the bale shall not exceed 37 kg.

8 SAMPLING AND CRITERIA FOR CONFORMITY

8.1 Lot

The quantity of canvas buckets delivered to a

buyer against one despatch note shall constitute a lot.

8.2 The conformity of the lot shall be determined on the basis of the tests carried out on the samples selected from it.

8.3 Unless otherwise agreed to between the buyer and the seller, the number of buckets to be selected at random from a lot for non-destructive and destructive testing shall be according to col 2 and 4 of Table 1.

8.4 The number of buckets selected in **8.3** for non-destructive testing shall be examined for general make-up (*see* 5.1) various dimensions (Fig. 1 and 5.2) manufacturing particulars, workmanship, appearance and shade and also tested for waterproofness requirement (*see* 5.3).

8.5 The number of buckets selected in **8.3** for destructive testing shall be examined for the requirement of the materials and indicated in 3.1.

8.6 Criteria for Conformity

8.6.1 The lot shall be declared as conforming to the requirements of this specification if the following conditions are satisfied:

- The number of buckets found not conforming to in conformity with the requirements for any one or more of the characteristics mentioned in **8.4** is less than or equal to the corresponding acceptance number given in col 3 of Table 1.
- The number of buckets found not conforming to the requirements for materials used in the manufacture of the bucket (*see* 3.1) is less than or equal to the corresponding acceptance number given in col 5 of Table 1.

Table 1 Sample Size and Permissible Number of Non-Conforming Buckets

(Clauses 8.3 and 8.6.1)

Lot Size	Non-Destructive Testing		Destructive Testing	
	Sample Size	Permissible No. of Non-conforming Pieces	Sample Size	Permissible No. of Non-conforming Pieces
(1)	(2)	(3)	(4)	(5)
Up to 300	13	1	2	0
301 to 500	20	1	3	0
501 to 1 000	32	2	5	0
1 001 to 3 000	50	3	8	0
3 001 and above	80	5	13	1

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